

CLAIMS

1. Apparatus for adding supercritical and therefore substantially incompressible gas to a molten plastic material, with gas injectors which open into the mixing stage of a screw which also serves for plasticising the plastic material, characterised in that disposed immediately upstream of the gas injectors (5) is a metering piston (18) whose travel speed is proportionally greater, the greater is the return travel speed of the screw (4) in the plasticising procedure. 20

2. Apparatus as set forth in claim 1 characterised in that the metering piston (18) is part of a pressure booster (10).

Sub A1
3. Apparatus as set forth in claim 1 or claim 2 characterised in that there is provided a sensor (6) for measuring the molten material pressure.